

Work Order ID 85375

June-07-12 9:19:18 AM

85375

Page 1

Item ID: D412-698-015

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Door Support

Stop ***NS2***

Start Date: 07/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 21/06/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/07 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	Rev E								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D412-698-015 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

JB 5/26/13

JB for MLJ 12-6-27
(2)

2

12/06/27 JB
(2)

5/26/13

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D412-698-015

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Door Support

Stop ***NS2***

Start Date: 07/06/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 21/06/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-698-015								
	Location: _____								
	PPP Rev: <u>A</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

2x 12-4-38

12/7/4

unc
12-07-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85375

85375

Parent Item: D412-698-015

D412-698-015

Parent Item Name: Door Support

Start Date: 07/06/2012

Required Date: 21/06/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C Removed Manufacturing 06-01-25 JLM
IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD10L

NAS1149D0332J

Purchased

No

110

Each

0.0000

12

24

✓

AN960JD10L

Washer

D3200-1

Manufactured

No

110

Each

37.0000

2

4

✓

D3200-1

Door Post Block

Location

Loc Qty

Loc Code

ST033

37

79034

7

82154

30

79034

D3200-3

Manufactured

No

110

Each

41.0000

2

4

✓

D3200-3

Door Wedge

Location

Loc Qty

Loc Code

ST033

41

79798

11

82155

30

79798

D3201-1

Manufactured

No

110

Each

3.0000

2

4

✓

D3201-1

Doubler

Location

Loc Qty

Loc Code

ST033

3

68968

1

79035

2

2x 79035

**

**

**

**

12/708 JB

JB SP

JB

12/06/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 85375

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Parent Item: D412-698-015

D412-698-015

Parent Item Name: Door Support

Start Date: 07/06/2012

Required Date: 21/06/2012

Start Qty: 2.00

Required Qty: 2.00

D3201-3

Manufactured No

110 Each

18.0000

D 2 ✓

D3201-3

Doubler

**

JB

Location

Loc Qty

Loc Code

ST033

18

71661

18

110 Each

31.0000

U 2 ✓

71661

D3201-4

Manufactured No

D3201-4

Doubler

**

JB

Location

Loc Qty

Loc Code

ST033

31

82357

12

83507

19

110 Each

2,101.000

U 24 ✓

82357

MS21042L3

Purchased No

MS21042L3

Nut

**

JB

Location

Loc Qty

Loc Code

ST300

2101

115835

4

117885

32

119017

929

119075

138

121349

188

121444

810

110 Each

47.0000

U 24 ✓

121444

MS24693-S277

Purchased No

MS24693-S277

Screw

**

JB 12/06/27

Location

Loc Qty

Loc Code

ST288

47

117591

1

120986

46

120986

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: E

Date: 08.05.01